Work Order ID 107802 \*107802\* Page 1 October-03-13 9:05:01 AM Item ID: D3121-143 Accept \*N900040100\* Setup Start **Revision ID:** Stop Bracket Assembly Item Name: **Start Date:** 10/03/13 Start Qty: 6.00 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 10/17/13 **Customer:** Reference: Start Run Process Plan: MLJ Date: 13-10-03 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Description Work Center ID Number Stamp **Run Hours** Code Qty **Qty Revision Nbr Draw Nbr** D3121 Rev E 100 0.00 **BAND SAW** \*100\* \$13.10-15 Bandsaw 0.00 Jeaspa Bandsaw Cut blanks: (1.250" x 2.000") 4.425" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 \*110\* HAAS 1 0.00 Memo 1-Machine D3121-113 as per Folio FA330 and Dwg D3121 HAAS CNC vertical machine #1 Identify as D3121-113 2-Deburr 3-Scribe batch number 120 QC2- Inspect parts off machine FAI/FAIB 0.00 DAS: \*120\* 13/10/21 QC 0.00 Memo Quality Control

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	CON	FORN	/ANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.			***************************************		Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					F.	AULT	CATE	GORY				

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

**Landing Gear** 

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Work Ord				*107	7802*						Page 2	
Item ID: Revision ID: Item Name:	D3121-143 Bracket Asse	mbly		Accept	*N900	<b>04</b> 0	100	<b>)*</b> s	etup Star Stop		S1* S2*	
Start Date: Required Date: Reference:	10/03/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1) Customer:	D:				1 <b>U</b>		
Approvals:		an:		Tooling: SPC (Y/N):		ite:		R	tun Star Stop	, "I <b>V</b> I	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description QC8-Inspect parts - seco	nd check	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*130* QC Quality Control		Мето		0.00	mL 13/10	23		<u></u>	15			
140 <b>*140*</b> Small Fab		Small Fab		0.00				6x			13/10/5	\$ (0 ¢
Small Fab		<b>Memo</b> Assemble D	3121-143 as per Dwg D312	1.							//	
*150 *150* QC		QC5- Inspect part comple	eteness to step on W/O	0.00 J3 10	<b>79</b>			6				

Quality Control

DQA:	Date:		

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

	-11								QA Closed:	Dat	e:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N NCR N	o				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube  Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	1 A	ction	Sign &	-	
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		ļ									
Material [											
Setup [											
Other [											
Process			1								
Supplier											
Training			] ]								
Unapproved											
					F	AULT CA	ATEGORY				
Landir	ng Gear				General			<del></del>	1	r	
]	Bending			<u> </u>	Bend	Gra		_	Ovalized	1	Pressure/Forced
	Centre N	ot Conce	ntric to (	D/S	BOM/Route	<del></del>	dware	ļ	Over/Under	t t	Temperature/Cure
	Cracks			L	Broken/Damaged		ection Incomplete	<u> </u>	Part Incorre	, , , , , , , , , , , , , , , , , , ,	Weld
	Crushed/	Crimped		L	Burrs		ructions Incomplete	:/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination	$\blacksquare$	intenance	L	Part Moved		
	Heat Trea				Countersink	$\vdash$	labeled	L	Positioned V		<del></del>
	Inspectio	•	Tube	$oldsymbol{oldsymbol{oldsymbol{eta}}}$	Cut Too Short	$\mathbf{H}$	read		Power Loss/	Surge	Other
	Ripples in			<u> </u>	Drill Holes	Offs		•			
	Torque V			Դ  _	Drawing		of Calibration				
	Turning S	•		<u> </u>	Finish	<b>—</b>	of Sequence				
	Wave/Tv	vist in Tul	he		IFolio	I lOut	side Dimensions				

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Work Order ID 107802  October-03-13 9:05:01 AM		7802					•	Page 3				
Item ID: Revision ID:	D3121-143			Accept	*N900	<b>040</b>	100	)* 5	Setup	Start		S1*
Item Name:	Bracket Asser	mbly								Stop	*N:	S2*
Start Date:	10/03/13	Start Qty: 6.00	*6*		Cust Item I	D:						
Required Date:	: 10/17/13	Req'd Qty: 6.00	*6*		Customer:							
Reference:							_		_	C44		
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ıte:		ŀ	Run	Start	*N	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ıte:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
160		Identify as per dwg & Sto	ock Location:	0.00			DAS		. ,	1		
*160* Packaging Packaging		Memo	59236A	0.00			32 9-89		3 <i>/) - y</i>	125	(6)	
170 <b>*17 *1</b> QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			,	Rm ——	13/	10/29	mu /	13-10-29
												13-10-29

DQA:	D	ate:	

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

										QA	Closed:	Da	te:	
Work Order	·				DISPOSITION				AGAINST (	DEPAF	RTMENT	PROCESS		
Part No					Rework Scrap Use-as-is		!	Skid-tube Machining	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR No	o	. <u>.</u>			Work Order Update		mem	Large Fab	Composite		REC/3tol	Supplier	${f}$	Other
Root				Descri	ption of work order update	1	nitial	Act	tion	9	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Doc/Data														
quip/Tooling						İ								
Operator														
Material		ļ ·												
Setup													-	
Other			•											
Process				٠						1				
Supplier						1								
Training		İ												
Unapproved														
					F	AUL	T CATE	GORY						
Landin	g Gear				General		1		-					· 1
L	Bending			<u> </u>	Bend		Grain			_	alized			Pressure/Forced
L	Centre No	ot Conce	ntric to (	o/s	BOM/Route	$\sqcup$	Hardwa		Ļ		•	tolerance		Temperature/Cure
	Cracks			ļ	Broken/Damaged	<u></u>		ion Incomplete	ļ.	— (	rt Incorre			Weld
L	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Unclear	_	rt Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs			L	Contamination		Mainte	enance		— 1	rt Moved			
	Heat Trea	at			Countersink		Mislabe	eled	1	— 1	sitioned V	_		•
	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d	L	Po	wer Loss/	Surge		Other
	Ripples in	n Bend			Drill Holes		Offset							
	Torque V	Vaves in I	Extrusio	n L	Drawing		į	Calibration		_				
· [	Turning S	Sequence			Finish		Out of	Sequence						
	Wave/Tw	vist in Tul	be		Folio		Outside	Dimensions	•					

**Picklist Print** October-03-13 9:05:05 AM Work Order ID: 107802 \*107802\* D3121-143 \*D3121-143\* Parent Item: Parent Item Name: Bracket Assembly **Start Date:** 10/03/13 Required Date: 10/17/13 Start Qty: 6.00 Required Oty: 6.00 Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC Component Item ID/ Replacement Mfg/ Primary Unit of Qty on Qty per Kit Total Last Route Qty Date Item Name Item Location Measure Item ID Purch Location Seq ID Hand Issued Issued **Qty** M174B1.250X02.000 100 36.8000 0.368 No f Purchased 3 ff 13-10-15 \*M174B1 250X02 000\* \*\* 2.250' 17-4 SS Bar 1.250 x 2.00 Location Loc Qty Loc Code MAT049 36.8 114899 2 M126132 12.45 2.2561 M126806 22.35 D3121-21

Manufactured

No

Bolt

Location Loc Oty Loc Code ST235 28 102053 1 102765 105619 22 99292

140

Each

28.0000

2

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12

DAS 36

Page 1

Status

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			·

							,		QA Closed:	Date	:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality
NCR N	0.				Use-as-is Work Order Update	}   'ne	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material		1									
Setup											
Other											
Process											
Supplier		İ									
Training							ļ				
Unapproved						<u> </u>					
					F	AULT CA	TEGORY				
Landir	ng Gear			-	General				٦	. –	_
	Bending				Bend	Grai	n	<u></u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to C	o/s	BOM/Route	$\vdash$	ware	ļ	Over/Under	•	Temperature/Cure
	Cracks				Broken/Damaged	<b>⊢</b> ⊢	ection Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/	'Crimped			Burrs	-	uctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs			$\vdash$	Contamination	$\vdash$	ntenance		Part Moved		
	Heat Trea			$\vdash$	Countersink	-	abeled	<u> </u>	Positioned \		<b>71</b>
	Inspectio		Tube		Cut Too Short	Misr			Power Loss/	'Surge	Other
	Ripples in				Drill Holes	Offs					
	Torque V			`	Drawing	$\vdash$	of Calibration	•			
	Turning 9	Sequence	<b>!</b>	1	Finish	Out	of Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-03-13 9:05:05 AM

Work Order ID: 107802

\*107802\*

\*D3121-143\*

Parent Item:

D3121-143

Parent Item Name: Bracket Assembly

**Start Date:** 10/03/13

Required Date: 10/17/13

Start Qty: 6.00

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Required Qty: 6.00

D3121-241

Manufactured

No

140

42.0000 Each

12

Bearing Assembly

Location		Loc Qty	Loc Code
FG <sub>.</sub>		14	
	89826	4	
	95927	10	
ST235		24	•
	105620	24	
ST235A		4	
	102098	2	
	102693	2	

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONI	FORM	MANCE / UPDATE		QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT/	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Crosstube Wachining Small Fab noforming Finishing Large Fab Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ini	itial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Description		Date	Verification	QC Inspector
Doc/Data							_					
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training						1						
Unapproved				<u> </u>							<b>.</b>	
					<del></del>	AULT	CATE	GORY				
Landi	ng Gear			_	General				_	7	_	7
	Bendin			_	Bend	$\mathbf{H}$	arain		<u>_</u>	Ovalized		Pressure/Forced
		Not Conce	ntric to	O/S	BOM/Route	$\vdash$	łardwa			Over/Under	<del></del>	Temperature/Cure
	Cracks				Broken/Damaged	-	•	on Incomplete	1	Part Incorred	<u> </u>	Weld
	<del></del> 1	d/Crimped			Burrs	$\boldsymbol{\vdash}$		ions Incomplete/Unclear	$\vdash$	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	$\vdash$		nance	$\vdash$	Part Moved		
	Heat Tr	eat			Countersink	ΙÍΝ	Mislabe	eled	1	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107802
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 1 of 2

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension						0.10 17
0.080	+/-0.010	.078	V/		NERN	P40-12
0.300	+/-0.010	. 300			11	• •
R0.375	+/-0.010	. 37S 1.540	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		Rad G	0.10
1.54	+/-0.030	1.540	V/-		VERU	PHO 12
0.350	+/-0.010	355			u	11
R0.25	+/-0.030	- 250			Rad G	
Ø0.392	+0.002/-0.000	. 393			Mic	P-10-02
Ø0.201	+0.005/-0.000	.201	W		VERN	P40-12
	±,010					
2.540	+/-0.010	2.539			NERN	P4D-12
1.590	+/-0.010	1,590			1.	
0.160	+/-0.010	. 160	V		. ` .	4.4
0.400	+/-0.010	. 410			/ \	1)
1.220	+/-0.010	1,230	V		. '	. (
1.600	+/-0.010	1,606	W		1 4	<i>r</i>
3.80	+/-0.030	3,800			4	1,
1.800	+/-0.010	1,805			<i>"</i>	. 1
R0.50	+/-0.030	. 500			Rad G	
0.130	+/-0.010	. 132	/		VERN	P40-12
3.41	+/-0.030	3.390	V		1.	,.
3.65	+/-0.030	3,630	6		H. G.	31006
2.24	+/-0.030	2 210			VERN	P40-12
45°	+/-0.1°	450			ANGLE G	
R0.25	+/-0.030	-250			Rad G	
3.97	+/-0.030	3,969	/		VGRN	P40-12
					0 ) (	
R0.38	+/-0.030	.375	V		Rad 6	0
Ø0.392	+0.002/-0.000	.393	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		VGRN	PUO-12
Ø0.201	+0.005/-0.000	. 202	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	<u> </u>		1.
0.268	+/-0.010	. 268	V		11	
R0.260	+/-0.010	-260	V/		Rad 6	
0.080	+/-0.010	,080	V		ven∪	P16-12
0.300	+/-0.010	. 300	<i>'</i>		''	
0.381	+/-0.010	. 371			- 1	11
0.201	+/-0.010	.206			11	, 1
0.580	+/-0.010	.570		L	11	1.

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DART AEROSPACE LTD	Work Order:	107802
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 2 of 2

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.400			NEUS	P40-12
100°	+/-0.1°	100°			Angle 6	
0.032	+0.000/-0.010	.030			Mic	P40-09
	L OAS !			<u> </u>	<u> </u>	

Measured by:	40	Audited by:	and	Prototype Approval:	N/A
Date:	13/10/21	Date:	13/10/23	Date:	N/A

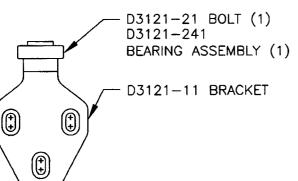
Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue P/O D3121-143	KJ/RF	
В	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
С	06.06.14	Dwg Rev. updated	KJ/JLM ,	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	- 2

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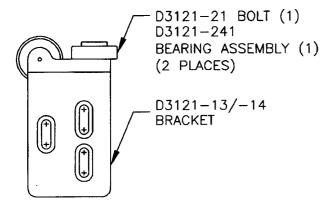
DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK	KED	APPROVED	DRAWING NO. REV. E		
	#		D3121 SHEET 1 OF 10		
DATE			TITLE SCALE		
07.1	1.07		BRACKET ASSEMBLY 1:2		
Α		02.04.15	NEW ISSUE		
В		03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146		
C		04.02.17	ADD CLEARANCE; USE -241 BEARING		
D		06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000		
E		07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)		

# RELEASE



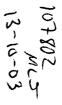
# D3121-041 BRACKET ASSEMBLY

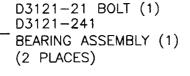
(REPLACES PREMIER P/N B30-23000-33)



# D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)





D3121-15/-16 BRACKET

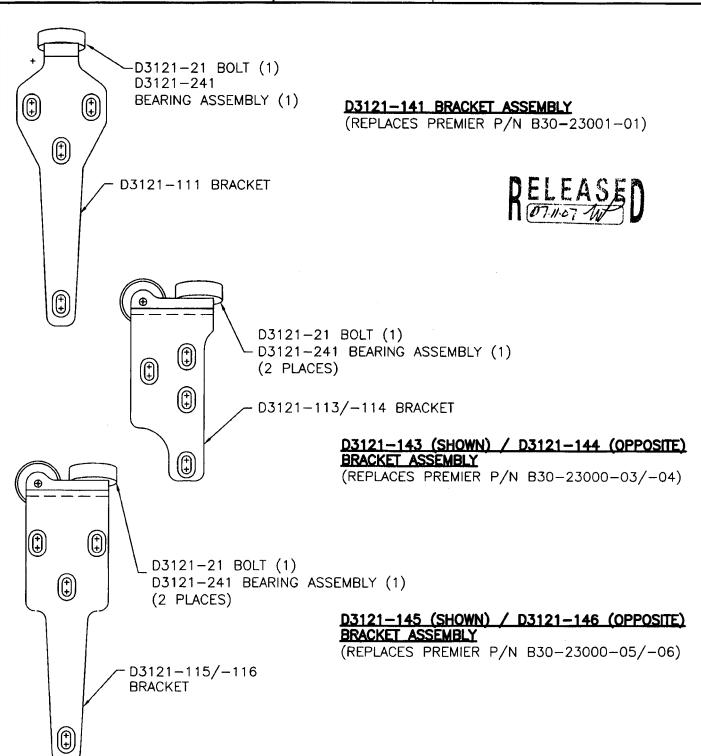
# D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

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DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. E
4	-	D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

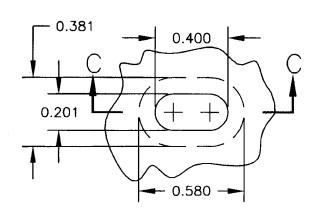


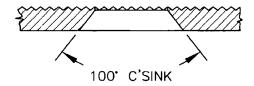
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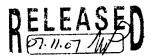
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
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#	<b>-M</b>	D3121	SHEET 3 OF 10		
DATE		TITLE	SCALE		
07.11.07		BRACKET ASSEMBLY	1:1		

**DETAIL A:** SLOT DETAIL SCALE 2:1 VIEW ROTATED

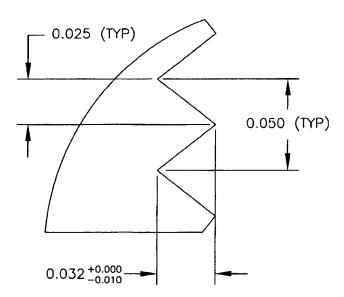








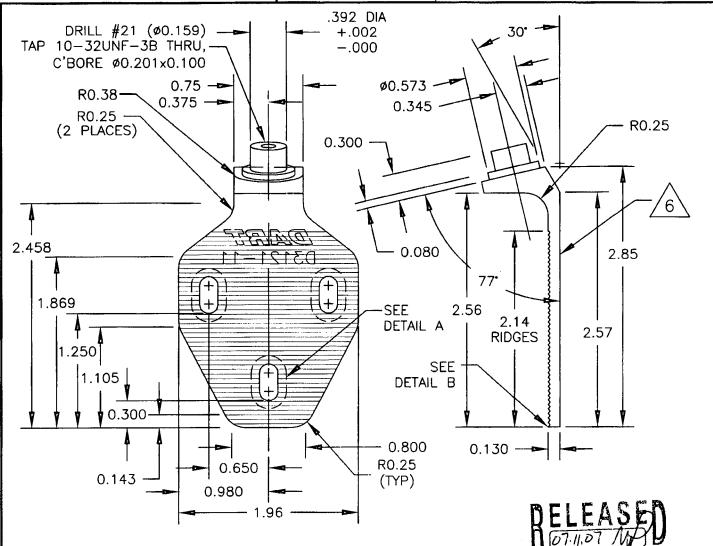
**DETAIL B:** RIDGE DETAIL PARTIAL SECTION SCALE 1:20



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### **D3121-11 BRACKET**

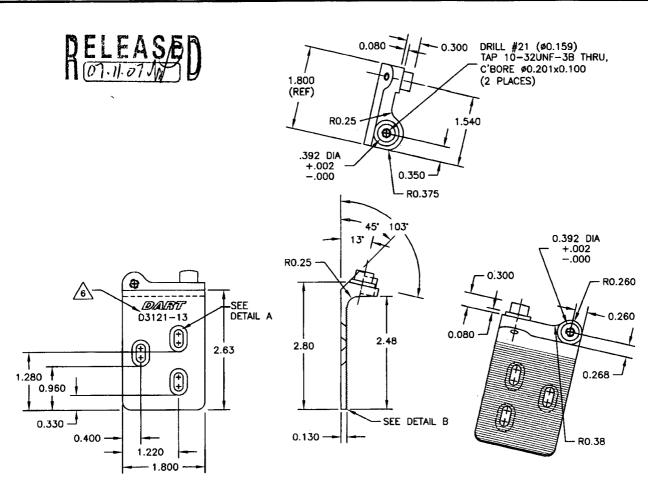
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
  MIN ULTIMATE TENSILE = 150 ksi
  MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



# D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

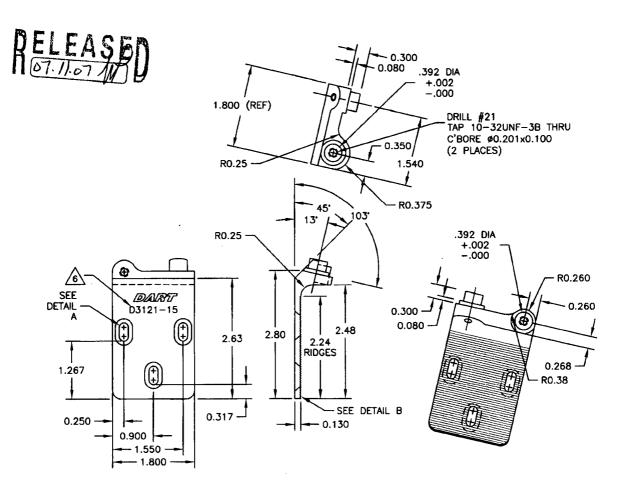
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
  MIN ULTIMATE TENSILE STRENGTH = 150 ksi
  MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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07.11.07		BRACKET ASSEMBLY	1:2	



# D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

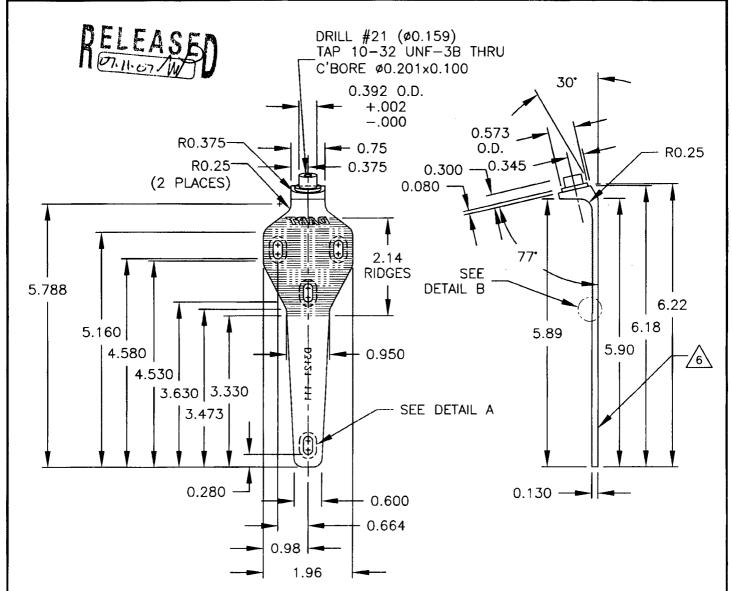
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
  MIN ULTIMATE TENSILE = 150 ksi
  MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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07.11.07		BRACKET ASSEMBLY	1:2	



# D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

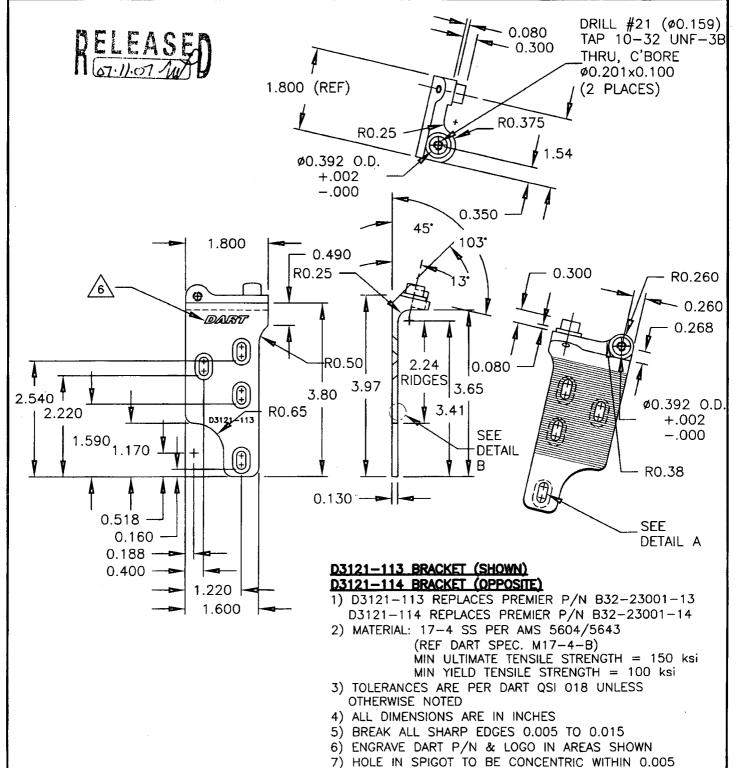
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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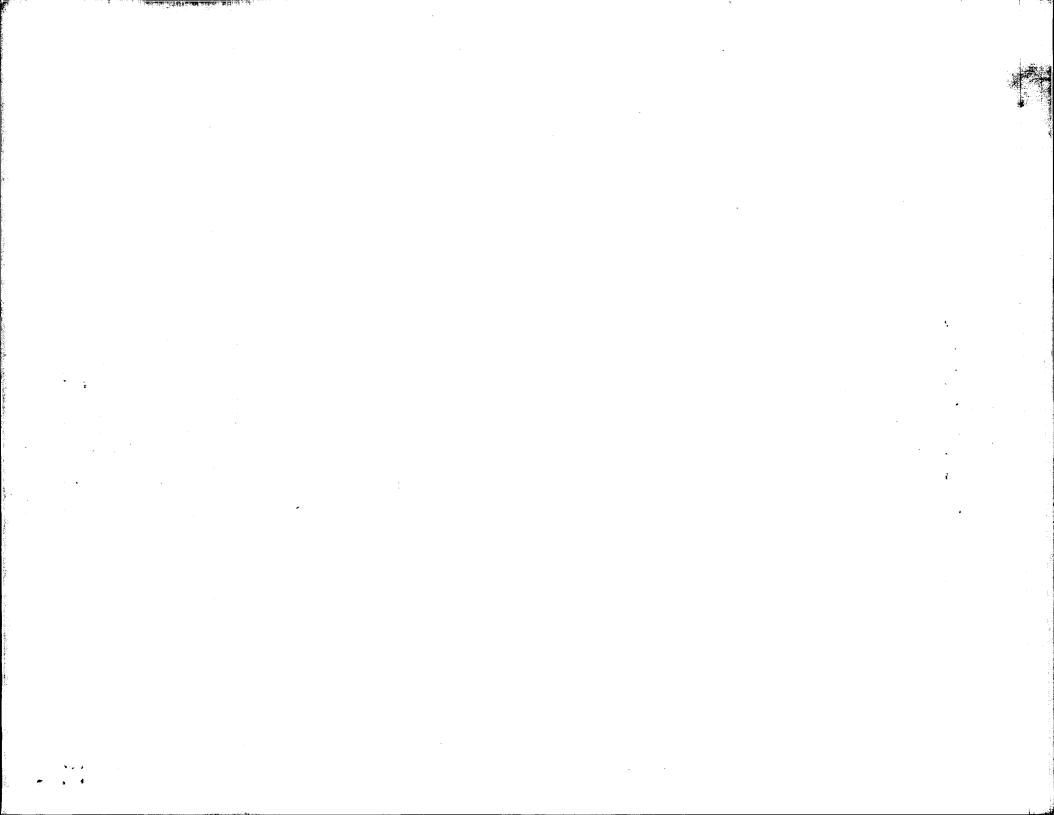
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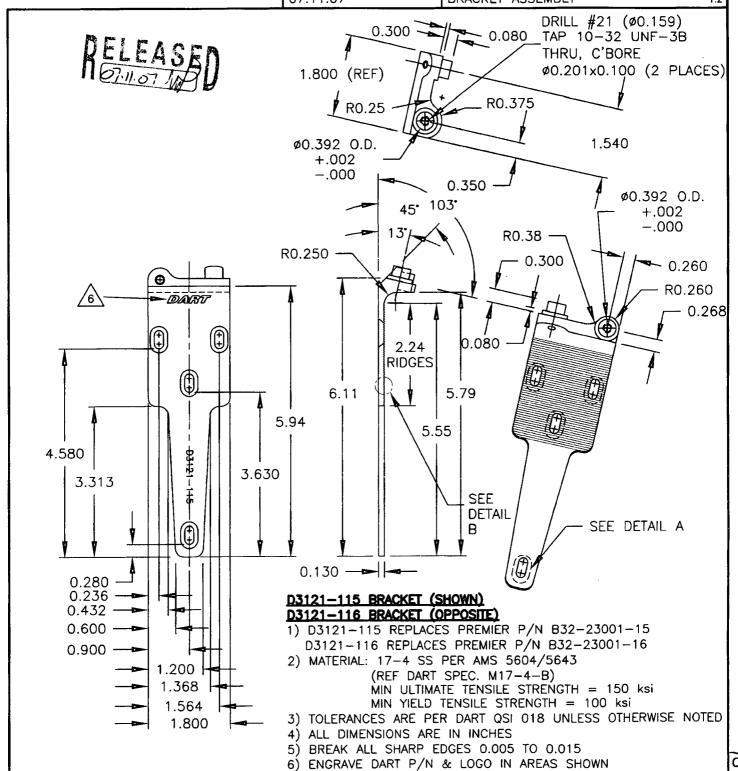


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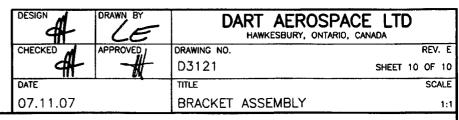


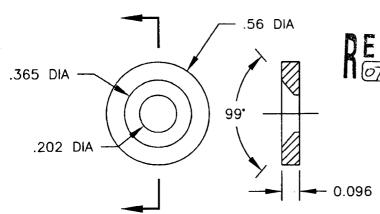
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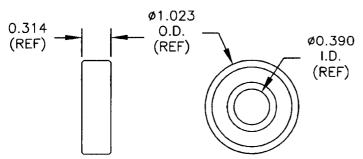






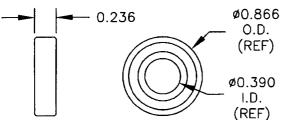
# D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



# D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

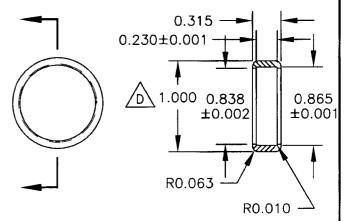


- D3121-23 BEARING (SCALE 1:1)
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

# 0.375 TAP 10-32 UNF-3A 0.080 0.050 TO 0.060

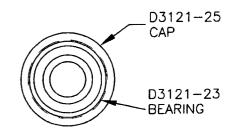
# D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



# D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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